

Work Order ID 59340

Tuesday, June 01, 2010 3:15:29 PM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3916	A

100

0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

SA 10-06-09

⑥ 10-06-09

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SA 10-06-09

⑥

Quality Control

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/6/06/09

86

Quality Control

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

SAD 10-06-09

2

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/10

Quality Control

mf 10-6-10

Picklist Print

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Page 1

Work Order ID: 59340

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 6/1/2010

Required Date: 6/7/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	114.0000	7	42			



Bushing

Pl 10-06-09

Location	Loc Qty	Loc Code
WA	114	
54072	9	
58159	1	
58256	26	
58581	42	
58672	36	

M304TS0.750W.049

Purchased

No

100

f

100.5164

4.166

26.31158



304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT	100.5163789	
113763	0	
114323	33.2519289	
114677	67.26445	
MAT017	3.68448E-05	
114298	3.6845E-05	

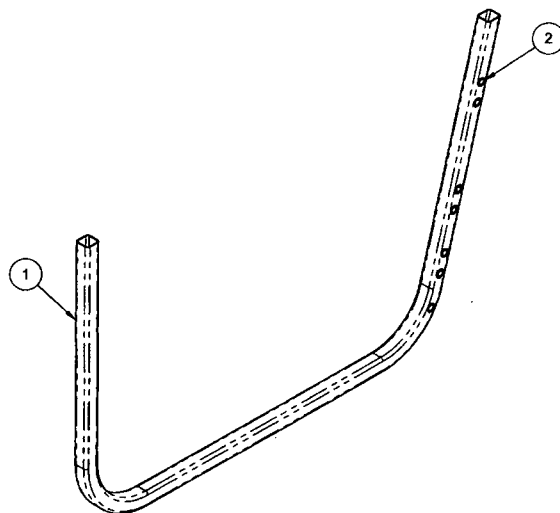
m 114835

(17) 825

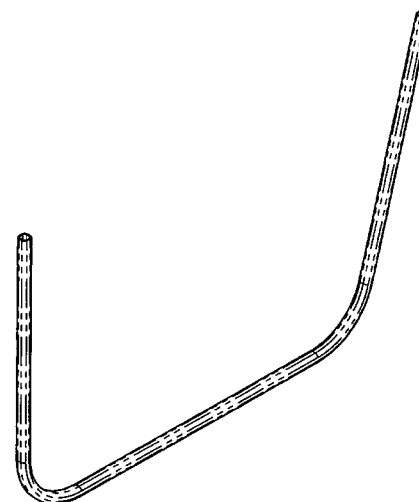
SAD 10-07-08

26.3115

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY

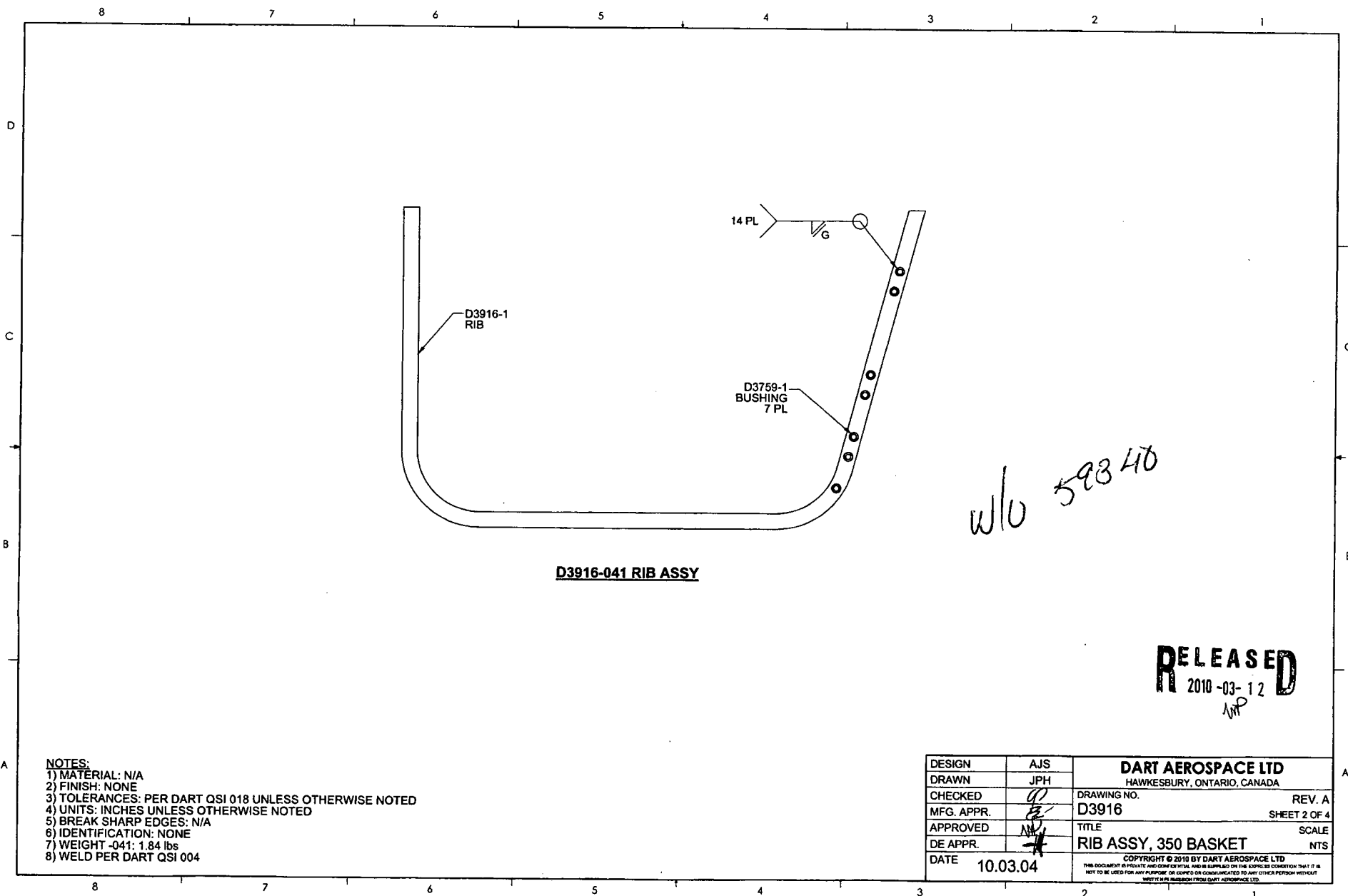


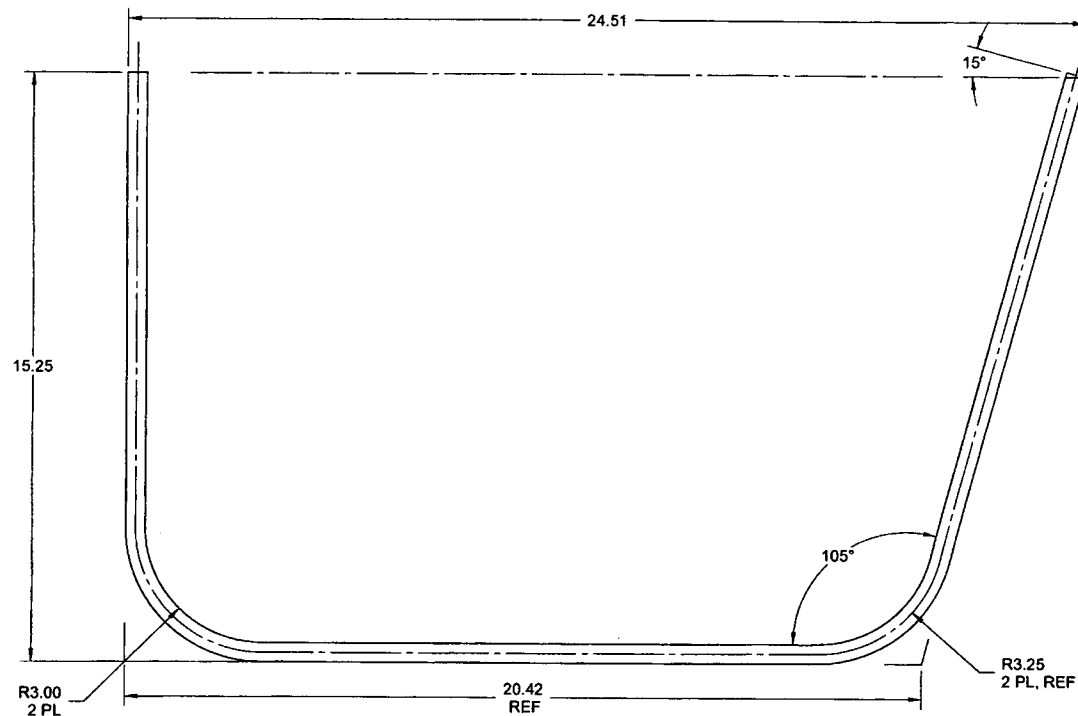
D3916-5 LIGHT RIB

SHOWN BY
RE
ENC
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK ORDER
NO. 59340
210-601

RELEASED
2010-03-12
MP

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	JPH					SHEET 1 OF 4	
CHECKED	<i>[Signature]</i>	DRAWING NO.		D3916		SCALE	
MFG. APPR.	<i>[Signature]</i>	TITLE		RIB ASSY, 350 BASKET		NTS	
APPROVED	<i>[Signature]</i>	DATE		10.03.04		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





9 D3916-5 LIGHT RIB

w/059340

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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